

Work Order ID 53818-1

November 18, 2009 4:07:03 PM



Beaupen

Page 1

Item ID: D4015-041

Accept



Setup Start



Revision ID:

Item Name: Wearbar Weldment

Stop



Start Date: 11/18/2009 Start Qty: 100.00



Cust Item ID:

Required Date: 11/24/2009 Req'd Qty: 100.00



Customer:

Reference:

Approvals:

Process Plan: *umf*

Date: 09-11-19

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4015

B

100

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

EL 9-11-23 (x2)

110

Weld per dwg A/R Hardcoat S.S. Batch: *m112963* 0.00



Large Fab

Memo

0.00

Large Fab

EL 9-11-23 (x2)

120

~~QC5- Inspect weld~~ *QC5- Inspect part completeness to step on W/O* 0.00



QC

Memo

0.00

Quality Control

→ Solutzy

count (x2)

(x2)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
5/1/24		ADD STEP for QC to inspect weld					<i>[Signature]</i> 5/1/24	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53818

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Page 2

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

2) S 09/11/24

cate
(21)

/

Memo

0.00

135



Powdercoat

Powder Coating

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

11/09/09/1

Memo

0.00

POWDER COAT:

Start Time: 9:00

Oven Temperature: 320°

Finish Time: 9:30

11/09-11-24

(21)

136



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

=> m-k 09/11/24

(21x)

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Work Order ID 53818

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Page 3

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Setup Start



Revision ID:

Stop



Item Name: Wearbar Weldment

Start Date: 11/18/2009 Start Qty: 100.00



Cust Item ID:

Required Date: 11/24/2009 Req'd Qty: 100.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140



Packaging

Packaging

Identify as per dwg & Stock Location: THE CHOPIN 21

Memo

0.00

21

09/11/24 X21

150



QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

09/11/24 AF

MR
09-11-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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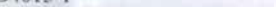

NOTE: Date & initial all entries

November 18, 2009 4:07:03 PM

Page 1



Required Qty: 100.00

Component Item ID/	Replacement	Mfg/ Manufactured	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D4015-1			No			100	Each	0.0000	100.0000			
										53819.	EL	7-11-24
Wearbar												

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

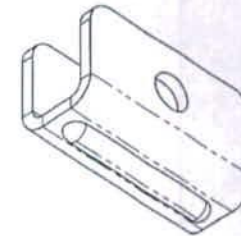
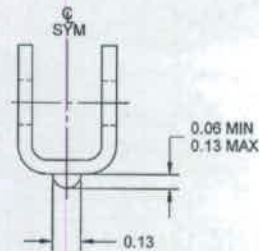
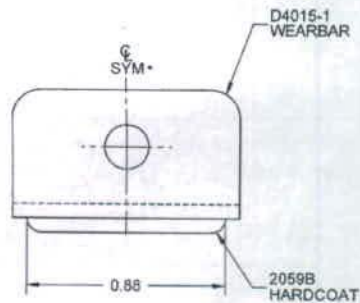
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY	P/N	DESCRIPTION
1	1	D4015-041	WEARBAR WELDMENT
11	1	D4015-1	WEARBAR
21	A/R	2059B	HARDCOAT



D4015-041 WEARBAR WELDMENT

NOTES:

- 1) MATERIAL: SEE SHEET 2 FOR D4015-1
- 2) FINISH: POWDER COAT "BLACK SANDETEX" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs
- 8) WELDING: PER DART QSI 004

B	CHANGED COLOR TO BLACK SANDETEX	MB	09.11.13
A	NEW ISSUE	MB	09.10.23
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.11.13		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4015** REV. B
SHEET 1 OF 2
TITLE **WEARBAR WELDMENT** SCALE NTS

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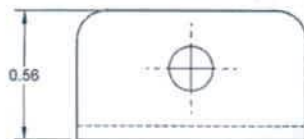
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

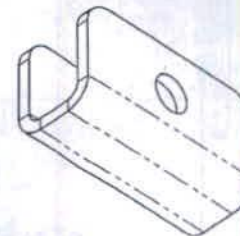
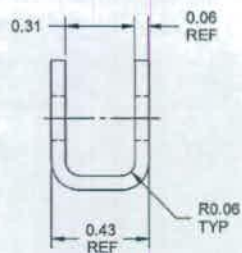
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

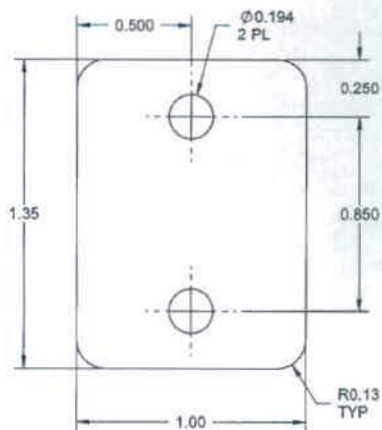
NOTE: Date & initial all entries



D4015-1 WEARBAR
MAKE FROM D4015-1



#53818



D4015-1F WEARBAR FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 16 GAUGE (0.063 THICK)
PER AMS 5513 (304) OR 5524 (316) OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4015	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	WEARBAR WELDMENT	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

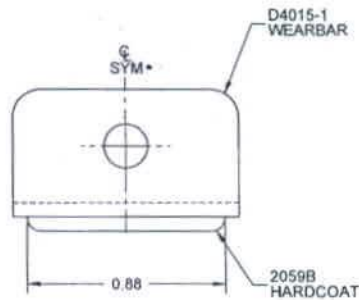
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

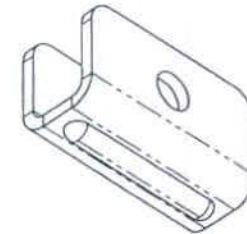
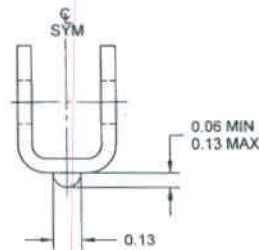
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY	P/N	DESCRIPTION
1	1	D4015-041	WEARBAR WELDMENT
11	1	D4015-1	WEARBAR
21	A/R	2059B	HARDCOAT



D4015-041 WEARBAR WELDMENT



NOTES:

- 1) MATERIAL: SEE SHEET 2 FOR D4015-1
- 2) FINISH: POWDER COAT "BLACK SANDEXT" (4.3.5.7) PER DART QSI 005 4.3 B
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs
- 8) WELDING: PER DART QSI 004

B	CHANGED COLOR TO BLACK SANDEXT	MB	09.11.13
A	NEW ISSUE	MB	09.10.23
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.11.13		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D4015

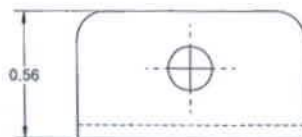
TITLE
WEARBAR WELDMENT

REV. B
SHEET 1 OF 2
SCALE
NTS

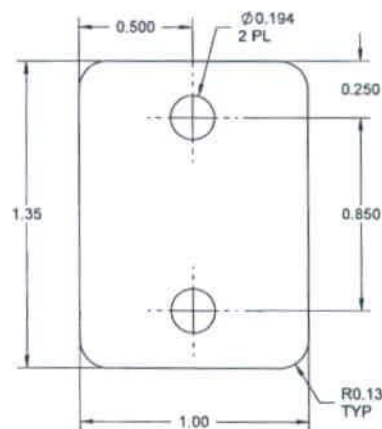
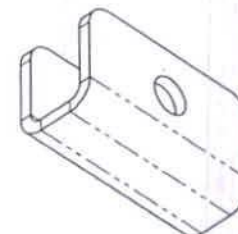
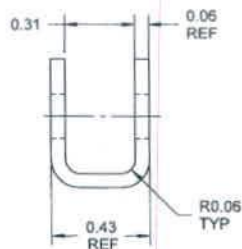
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RELEASED
2009-11-24
MD

53818



D4015-1 WEARBAR
MAKE FROM D4015-1



D4015-1F WEARBAR FLAT PATTERN

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- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>AS</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>DS</i>	D4015	SHEET 2 OF 2
APPROVED	<i>W</i>	TITLE	SCALE
DE APPR.	<i>H</i>	WEARBAR WELDMENT	NTS
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2009-11-24

